

Work Order ID 76255

November-08-11 7:48:33 AM

76255

Page 1

Item ID: D350-748-201 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Installation, High Aft
 Start Date: 08/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 28/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 11/11/08 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-748-241	F								

100 0.00
100 DOCUMENT CONTROL
 DC Memo
 Document Control Photocopy bluefile & type labels per PPD350-748-201 CHG002

110 0.00
110 BENDING MACHINE - CROSSTUBES
 CNC Bend 2 Memo
 CNC Alpha 160 Bender Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT _____

120 0.00
120 QC15- Crosstube Dimensional Check
 QC Memo
 Quality Control

Pro →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-718-201 PAR #: _____ Fault Category: landing gear/cross tubes NCR: Yes No DQA: Not Date: 12/03/16
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: OK Date: 12/3/16

NCR: <u>12-1250</u>		WORK ORDER NON-CONFORMANCE (NCR) <u># 2928.10</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/01/25	# 110	tube kinked during Bending on inside of tube. @ 20-26" from cap. R.C.	<u>Cell</u> <u>12/01/25</u> <u>2042</u>	- SCRAP + Destru No Replac	<u>NO</u> <u>12/1/25</u>	<u>D</u> <u>12-125</u>	<u>Cell</u> <u>12/01/25</u> <u>2042</u>	<u>S</u> <u>12/01/25</u>

NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 08/11/2011 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 28/11/2011 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

125

0.00

125

0.00

HandFXtube

Memo

Hand Finishing Crosstubes

Stress relief

Heat treat crosstube as per QSI010 4.3

Temp:

Start time:

Finish time: _____

127

QC5- Inspect part completeness to step on W/O

0.00

127

0.00

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100

Setup Start *NS1*

Stop *NS2*

*** 1 ***

Cust Item ID:

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

130

130

Crosstubes

Crosstubes

Crosstubes

Memo

1-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs,
Set-up drill table as per QSI 010

2-Deburr

3-Engrave Part # and Batch # as per Dwg D350-748-241

4-Remove all marks from tube within limits of D350-748-241

5- Apply a light coat of LPS3 on the interior of tube
Batch:

140

140

QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

W/O:		WORK ORDER CHANGES					
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N900040100

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Stop *NS2*

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Required Date: 28/11/2011 **Req'd Qty:** 1.00 *** 1 ***

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Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150	Outsource process-Cadplate per OSI017 4.1.9.1	0.00
-----	---	------

150

Outsource3	Memo	0.00
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Outsource process - Cad plate

Memo

Issue P/O:

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

160	Receive & Inspect for Damage & Mat'l Certs	0.00
-----	--	------

160

Packaging	Memo	0.00
-----------	------	------

Packaging	Ensure certificate of conformity is attached
-----------	--

170	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

170

QC	Memo	0.00
----	------	------

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID 76255***76255***

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Item ID: D350-748-201

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Installation, High Aft

Start Date: 08/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 28/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
180	SprayPaint								
SprayPaint	Memo	0.00							
Spray Painting	1-Prime inside crosstube as per QSI 005 4.2 2-Paint Outside of Tube as per Dart QSI 005 4.2								
190	QC14- Inspect Spray Paint	0.00							
190									
QC	Memo	0.00							
Quality Control	Then, Wrap in plastic bag to protect from scratches								
200		0.00							
200	Crosstubes								
Crosstubes	Memo	0.00							
Crosstubes	1-Install Ground wire Insert, then insert screw and washer 2-Install Abrasion strips as per Dwg D350-748-241 & QSI 035. 3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-LBS								

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100

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Stop ***NS2***

Start Date: 08/11/2011 **Start Qty:** 1.00 ***1***

Required Date: 28/11/2011 **Req'd Qty:** 1.00 *** 1 ***

Reference:

Run Start *NR1*

Stop *NR2*

210	QC5- Inspect part completeness to step on W/O	0.00
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QC	Memo	0.00
----	------	------

220	Pick Kit	0.00
-----	----------	------

Packaging	Memo	0.00
-----------	------	------

230	QC4- 100% Inspect kits for completeness	0.00
-----	---	------

QC	Memo	0.00
----	------	------

Quality Control

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 Required Date: 28/11/2011 Req'd Qty: 1.00 ***1*** Customer:
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Packaging	0.00							
240									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-748-201 Location: _____ PPP Rev: _____								
250	QC21- Final Inspection - Work Order Release	0.00							
250									
QC	Memo	0.00							
Quality Control									

11-03-12
 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 76255

76255

Parent Item: D350-748-201

D350-748-201

Parent Item Name: Crosstube Installation, High Aft

Start Date: 08/11/2011

Required Date: 28/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2856-400

Manufactured

No

200

f

304.0945

1.181

1.243158

D2856-400

Abraison Strip

Location

Loc Qty

Loc Code

ST403

0.3149

68076

0.3149

ST409

303.7796

63735

0.6696

71164

87.11

73491

216

1- cut as per dwg D2856

D3502-1

Manufactured

No

200

Each

37.0000

2

2

D3502-1

Support

Location

Loc Qty

Loc Code

ST063

37

68951

3

72129

14

73419

20

MS21920-20

Purchased

No

200

Each

72.0000

2

2

MS21920-20

Clamp (per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

LG050

72

116799

10

118649

12

119386

50

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 76255

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Parent Item: D350-748-201

D350-748-201

Parent Item Name: Crosstube Installation, High Aft

Start Date: 08/11/2011

Required Date: 28/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-10

Purchased

No

200

Each

304.0000

1

1

MS27039-1-10

Screw

Location

Loc Qty

Loc Code

ST291

304

118612

154

119307

100

119531

50

AN4-41A

Purchased

No

220

Each

305.0000

8

8

AN4-41A

Bolt

Location

Loc Qty

Loc Code

ST360

305

115108

3

115705

7

116191

20

117619

50

117795

25

118451

50

118838

50

119328

100

AN4-6A

Purchased

No

220

Each

5,476.000

16

16

AN4-6A

Bolt

Location

Loc Qty

Loc Code

ST356

476

118838

276

119127

200

ST516

5000

119017

5000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 76255

76255

Parent Item: D350-748-201

D350-748-201

Parent Item Name: Crosstube Installation, High Aft

Start Date: 08/11/2011

Required Date: 28/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-32A	Purchased	No	220	Each	195.0000	4	4
---------	-----------	----	-----	------	----------	---	---

AN5-32A

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST339	195	
118422	20	
118628	50	
118983	25	
119328	100	

AN960JD416	NAS1149D0463J	Purchased	No	220	Each	0.0000	32	32
------------	---------------	-----------	----	-----	------	--------	----	----

AN960.ID416

Washer

AN960JD516	NAS1149D0563J	Purchased	No	220	Each	0.0000	8	8
------------	---------------	-----------	----	-----	------	--------	---	---

AN960.ID516

Washer

D3500-1		Manufactured	No	220	Each	16.0000	4	4
---------	--	--------------	----	-----	------	---------	---	---

D3500-1

Saddle

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST424	4	
70695	4	
ST427	12	
73407	12	

D3501-1		Manufactured	No	220	Each	237.0000	16	16
---------	--	--------------	----	-----	------	----------	----	----

D3501-1

Bushing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST063	237	
67757	4	
70682	100	
73391	133	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 76255

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Parent Item: D350-748-201

D350-748-201

Parent Item Name: Crosstube Installation, High Aft

Start Date: 08/11/2011

Required Date: 28/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

220

Each

12,685.00

24

24

MS21042L 4

Nut

Location

Loc Qty

Loc Code

ST300

1685

117441

51

117601

532

118451

133

118927

969

ST516

6000

119017

6000

ST518

5000

119075

5000

MS21042L5

Purchased

No

220

Each

2,358.000

4

4

MS21042L 5

Nut

Location

Loc Qty

Loc Code

ST300

858

116105

5

116548

43

117611

62

118179

496

118910

252

ST518

1500

119109

1500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

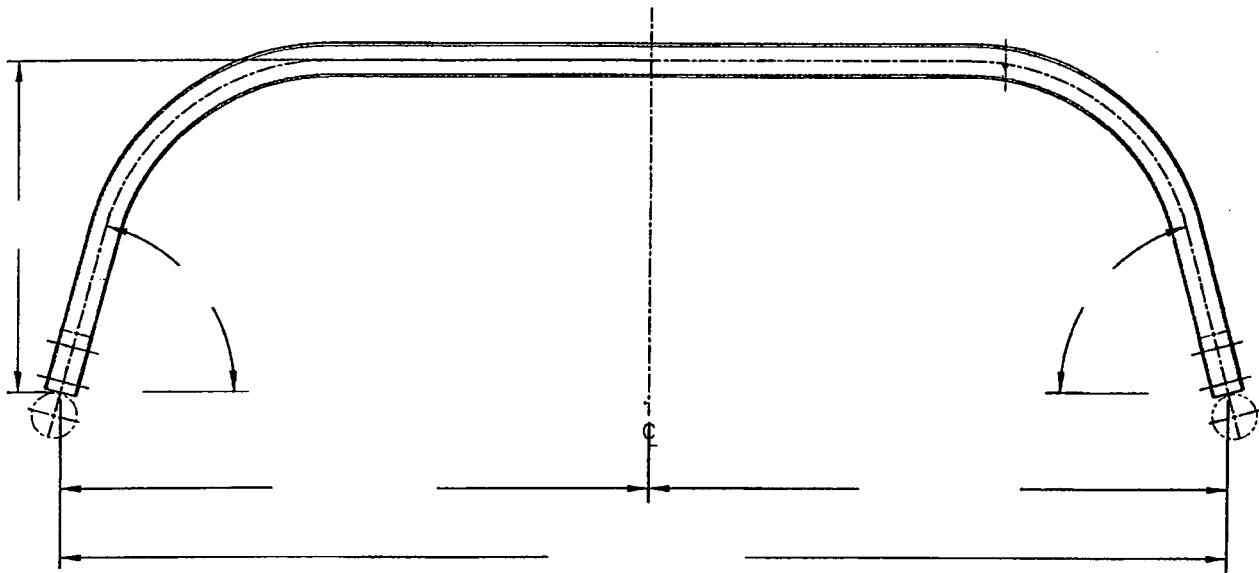
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 76255
Description: Crosstube High Aft (AS350/355)	Part Number: D350-748-201
Inspection Dwg: D350-748-241 Rev: E	Page 1 of 1

Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item	Qty -241	Part Number	Description
1	X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
2	1	D6015-125	CROSSTUBE (OR D6018-125)
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6015-125 OR D6018-125
FINISHED LENGTH = 122.700±0.06
- FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: DART PART NUMBER "D350-748-241" AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- WEIGHT: 29.85 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT ALL EDGES FROM MACHINING
LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER
BENDING.
- BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO
BENDING IS 6% BASED ON O.D.
- HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO
VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.
- INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE,
CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES,
NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY.
CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE
MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO
CRACKING/CHIPPING/GROOVES.
- TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT
NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN
CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

76255. H.C.J

11/11/08

RELEASED
R 2011-01-08
MP

F	ADD HRC TEST OPTION (B8-1) PER PAR 09-040, ADD TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION (C8-1), STOCK DIM NOW MACHINED (D1-4)	CP	10.11.23
E	REVISE GENERAL NOTES; UPDATE TO CURRENT STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A8-3); ADD TOLERANCES (ZN C6-3, D2-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6018-125 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	DP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DP		
CHECKED	DP	DRAWING NO.	REV. F
MFG. APPR.	DP	D350-748-241	SHEET 1 OF 4
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	10.11.23	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

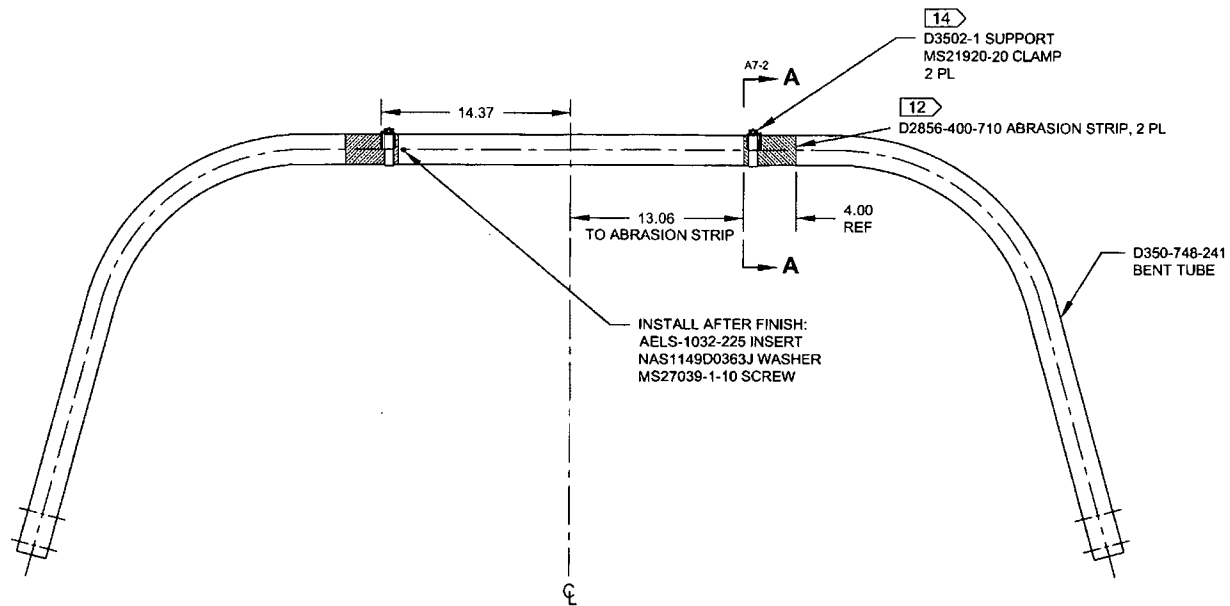
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

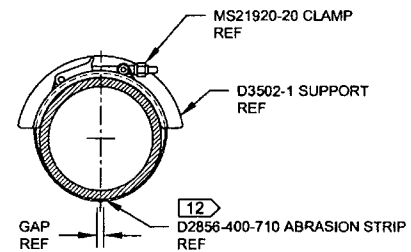
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76255



**D350-748-241
ASSEMBLY DETAIL**



SECTION A-A
SCALE 4X

RELEASED
2011-03-19

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D350-748-241	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE (AS 350/355 HI AFT)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

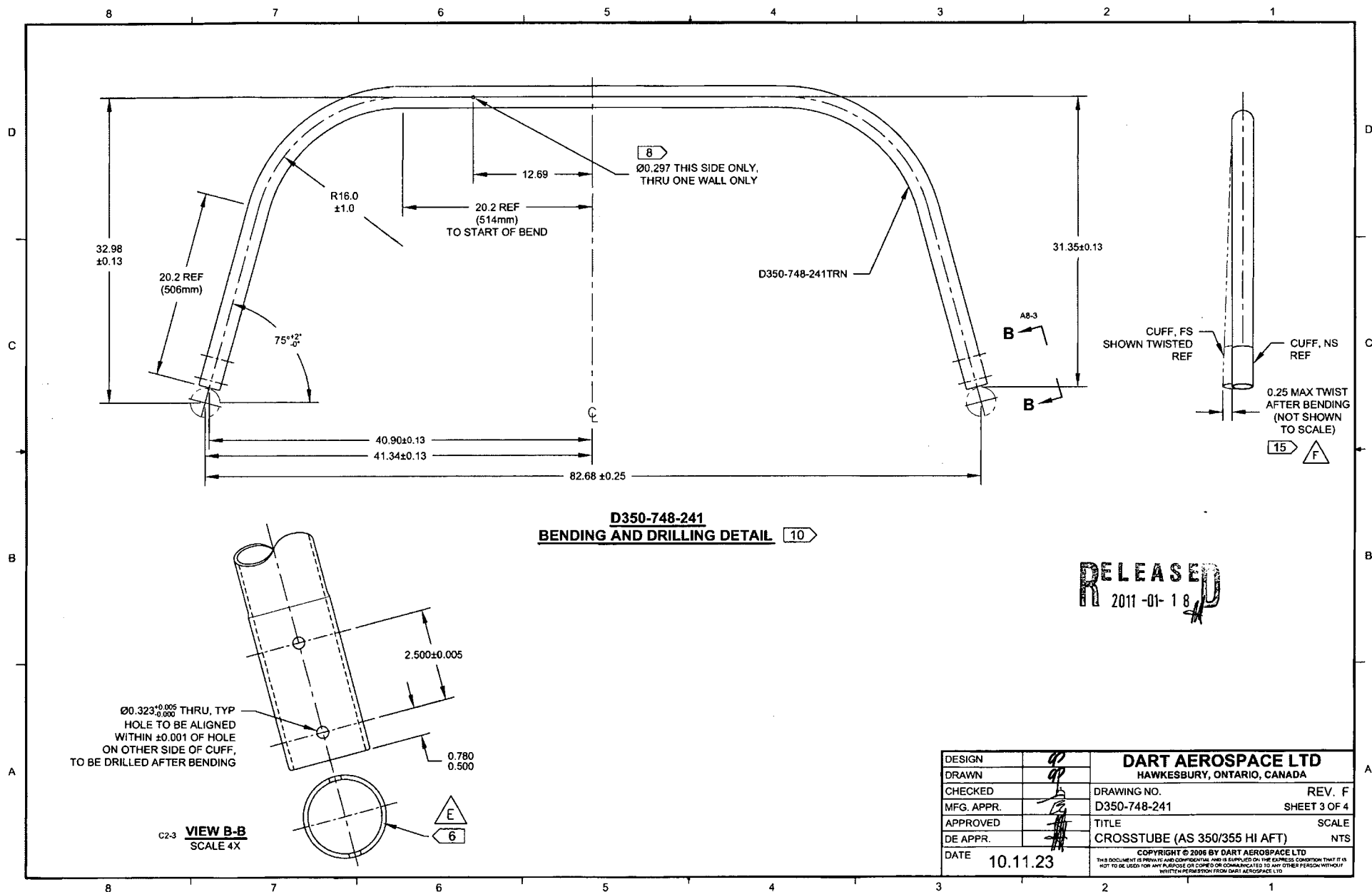
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76255



RELEASED
2011-01-18

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D350-748-241	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	10.11.23	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

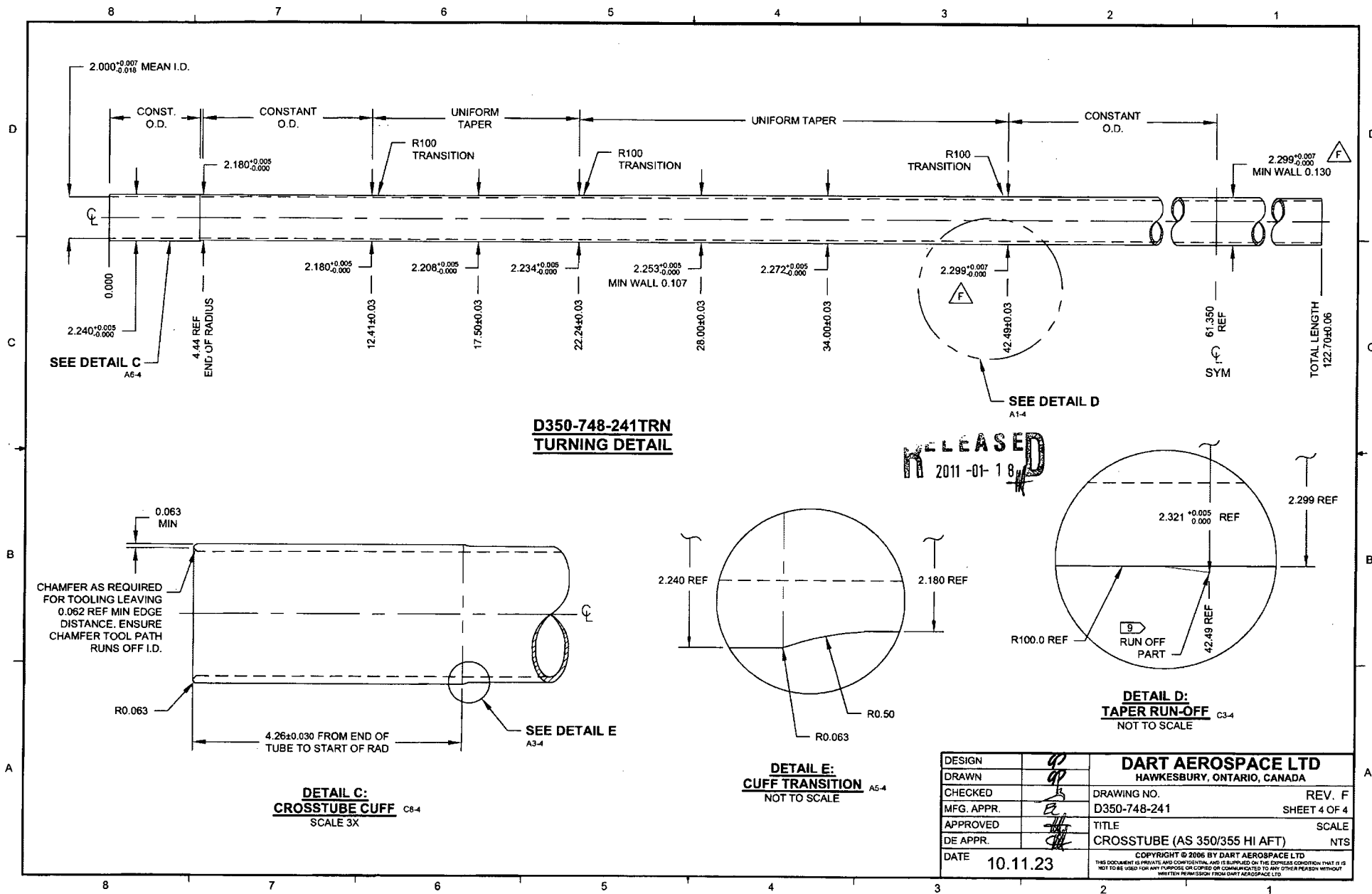
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76255



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries